

Work Order ID 64974

Wednesday, January 05, 2011 11:26:49 AM



Page 1

Item ID: D315-670-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Bearpaw

Start Date: 1/5/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 1/14/2011 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date:

1-05-1

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2432	Rev F3								
100		0.00							
	DOCUMENT CONTROL								
DC	Memo	0.00							
Document Control	Photocopy bluefile and create labels per PPP D315-670-011 CHG001								
150	Pick Kit	0.00							
Packaging	Memo	0.00							
Packaging									
160	QC4- 100% Inspect kits for completeness	0.00							
QC	Memo	0.00							
Quality Control									

Sublot 17

For BG 11/01/16

11/10 SLD

Sublot 17

(70)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D315-670-011

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Stop

Item Name: Bearpaw

Start Date: 1/5/2011 Start Qty: 1.00

Cust Item ID:

Required Date: 1/14/2011 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

170

Identify as per dwg & Stock Location: B

0.00

Rev A

1/11/11

SD

(12)



Packaging

Memo

0.00

Packaging

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/01/18

MF

11-01-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 64974

Parent Item: D315-670-011

Parent Item Name: Bearpaw



Start Date: 1/5/2011

Required Date: 1/14/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A New Issue 07-01-03 JLM
 IPP Rev:B 08-01-09 Added Step 2 JLM Verified By:EC
 IPP Rev:F 08-10-15 New Manufacturing Method JLM Verified By:EC
 IPP RevG: revise seq in route DD 10.01.13 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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AN4-17A Bolt		Purchased	No			150	Each	518.0000	12	12			
-----------------	--	-----------	----	--	--	-----	------	----------	----	----	--	--	--

Location	Loc Qty	Loc Code
ST358	500	
116400	100	
116419	400	
ST359	18	
112314	18	

AN960JD416 Washer	NAS1149D0463J	Purchased	No			150	Each	30.0000	24	24			
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Location	Loc Qty	Loc Code
ST300	24	
113288	24	
ST356	6	
115622	6	

D2182B Rubber Cushion		Manufactured	No			150	f	234.7960	2.5	2.5			
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Location	Loc Qty	Loc Code
ST410	234.796	
63413	234.796	

6x 5.00"
 MAX
 Satalyg
 cut @ 5.0" x 6 pcs.
 Satalyg

M116549 11/1/10
 M116304 SP
 11/1/10 SP (10)
 2.5

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 64974



Parent Item: D315-670-011



Parent Item Name: Bearpaw

Start Date: 1/5/2011

Required Date: 1/14/2011

Start Qty: 1.00

Required Qty: 1.00

MS21042L4

Purchased

No

150

Each

4,180.000

12

12



M116301

11/11/10

Nut

Location

Loc Qty

Loc Code

ST300

4180

1123143

2

115589

10

115621

668

116188

3500

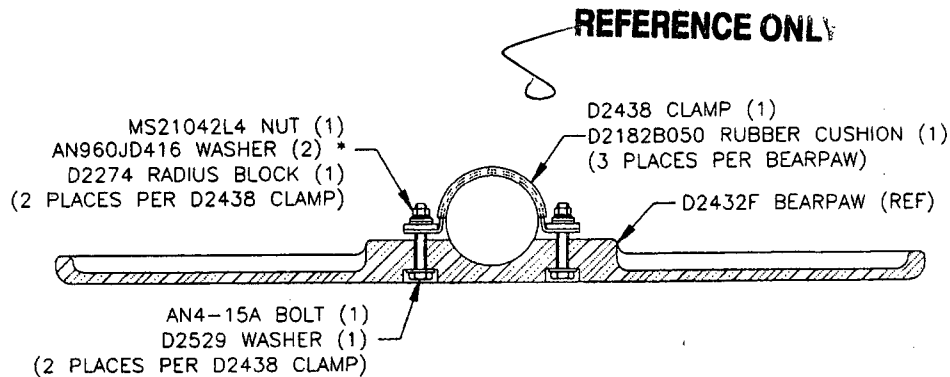
W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries



* Additional AN960JD416 washers may be added to ensure 2-4 threads remaining on bolt.

Figure 3 - Bearpaw Section - Clamp Installation

4. WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D315-670-011 Bearpaw	12.5 lb 5.67 kg	0.0 in 0.0 m	0.0 in-lb 0.0 m-kg	146.1 in 3.71 m	1826.3 in-lb 21.03 m-kg

5. PARTS LIST

Qty	Part Number	Description
X	D315-670-011	BEARPAW KIT
6	D2182B050	Rubber Cushion
12	D2274	Radius Block
2	D2432F	Bearpaw
6	D2438	Clamp
12	D2529	Washer
12	AN4-17A	Bolt
24	AN960JD416	Washers
12	MS21042L4	Nut (or MS21042-4)